

Tuesday, 4/24/2007 3:14:44 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	HI-STEP LEG ASSEMBLY
Job Number	32032		
Estimate Number	10385		
P.O. Number	N/A	Part Number	D3065041
This Issue	4/24/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3065 REV B
First Issue	N/A	Project Number	N/A
Previous Run	31794	Drawing Revision	B
Written By		Material	N/A
Checked & Approved By	<i>[Signature]</i> 07.04.25	Due Date	5/20/2007
Comment	Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF	Qty:	60
Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	32032A	STEP SPACER	
		Comment: Sub-Component STEP SPACER D3065-1 B <u>B 31794 (x35)</u>	<u>B 32032A (x25)</u>
2.0	32032B	STEP SPACER	
		Comment: Sub-Component STEP SPACER D3065-3 B <u>B 31794B (x15)</u>	<u>B 32032B (x45)</u>
3.0	32032C	STEP LEG	
		Comment: Sub-Component STEP LEG D3065-5 B <u>B 28738C (x8)</u>	<u>B 29978C (x16)</u>
4.0	32032D	STEP SPACER	
		Comment: Sub-Component STEP SPACER D3065-7 B <u>B 22366 (x9)</u>	<u>B 28738D (x2)</u> <u>B 32032(D) (49)</u>
5.0	MS20470AD44	Rivet, Universal Head	
		Comment: Qty: 30.0000 Each(s)/Unit Total: 1800.0000 Each(s) Rivet, Universal Head Pick: Qty Part Number Description Batch	<i>m 105/25</i> <i>M104885 (1800)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/08/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: HI-STEP LEG ASSEMBLY
Job Number: 32032		Part Number: D3065041
Job Number: 		
Seq. #:	Machine Or Operation:	Description:
6.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1  mf 07-08-09 ml 60
Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3065 and Identify as D3065-041		07.08. a.m.
7.0	QC5 	INSPECT WORK TO CURRENT STEP  En 07/08/09 60
Comment: INSPECT WORK TO CURRENT STEP		
8.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: U11		9.08.09 X60
9.0	QC21 	FINAL INSPECTION/W/O RELEASE  65
Comment: FINAL INSPECTION/W/O RELEASE		07/08/10
Job Completion 		07/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

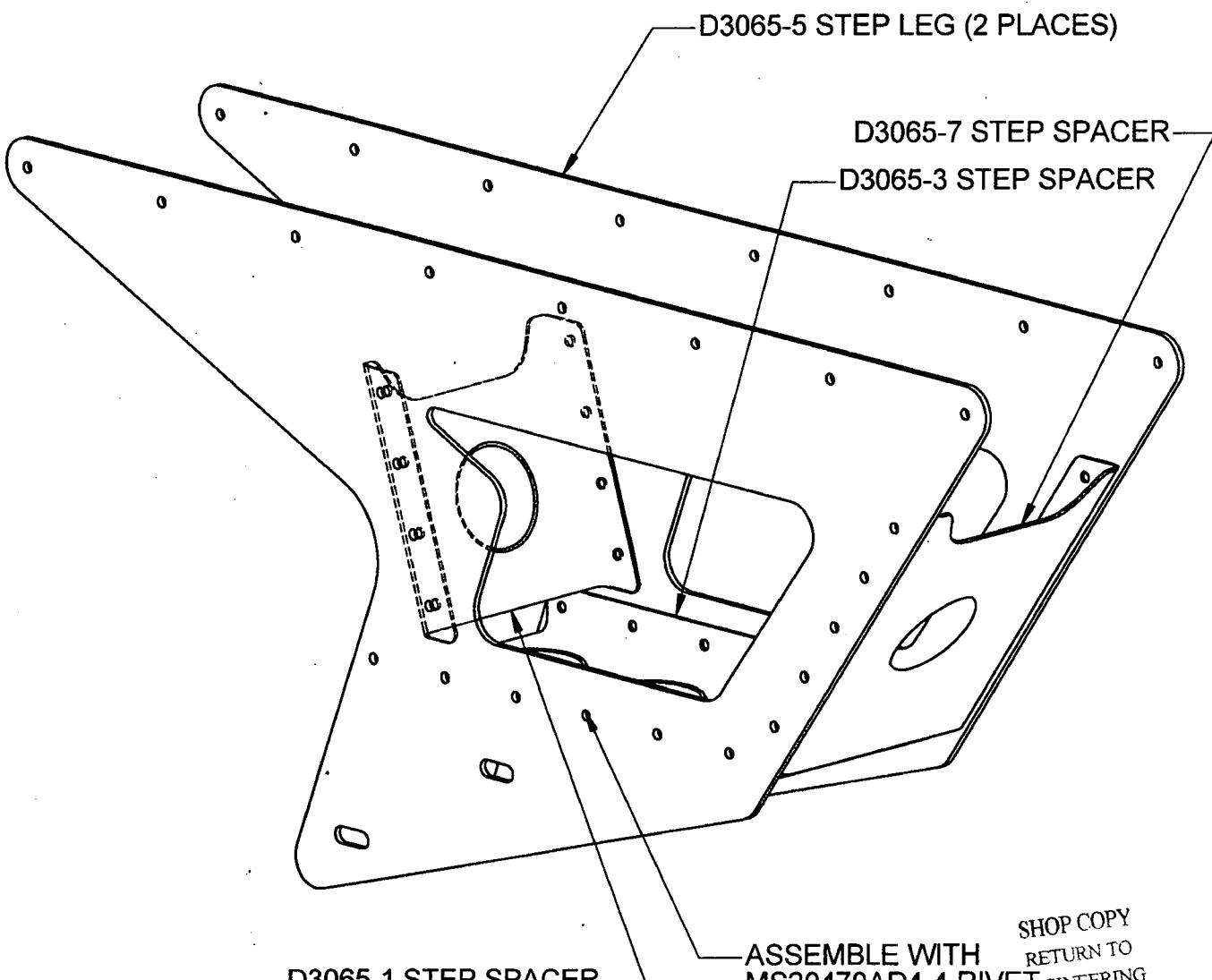
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065
DATE 06.05.23		REV. B SHEET 1 OF 5
		TITLE STEP LEG ASSEMBLY

A	02.09.11	NEW ISSUE
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5

RELEASED06.06.20 *[Signature]*

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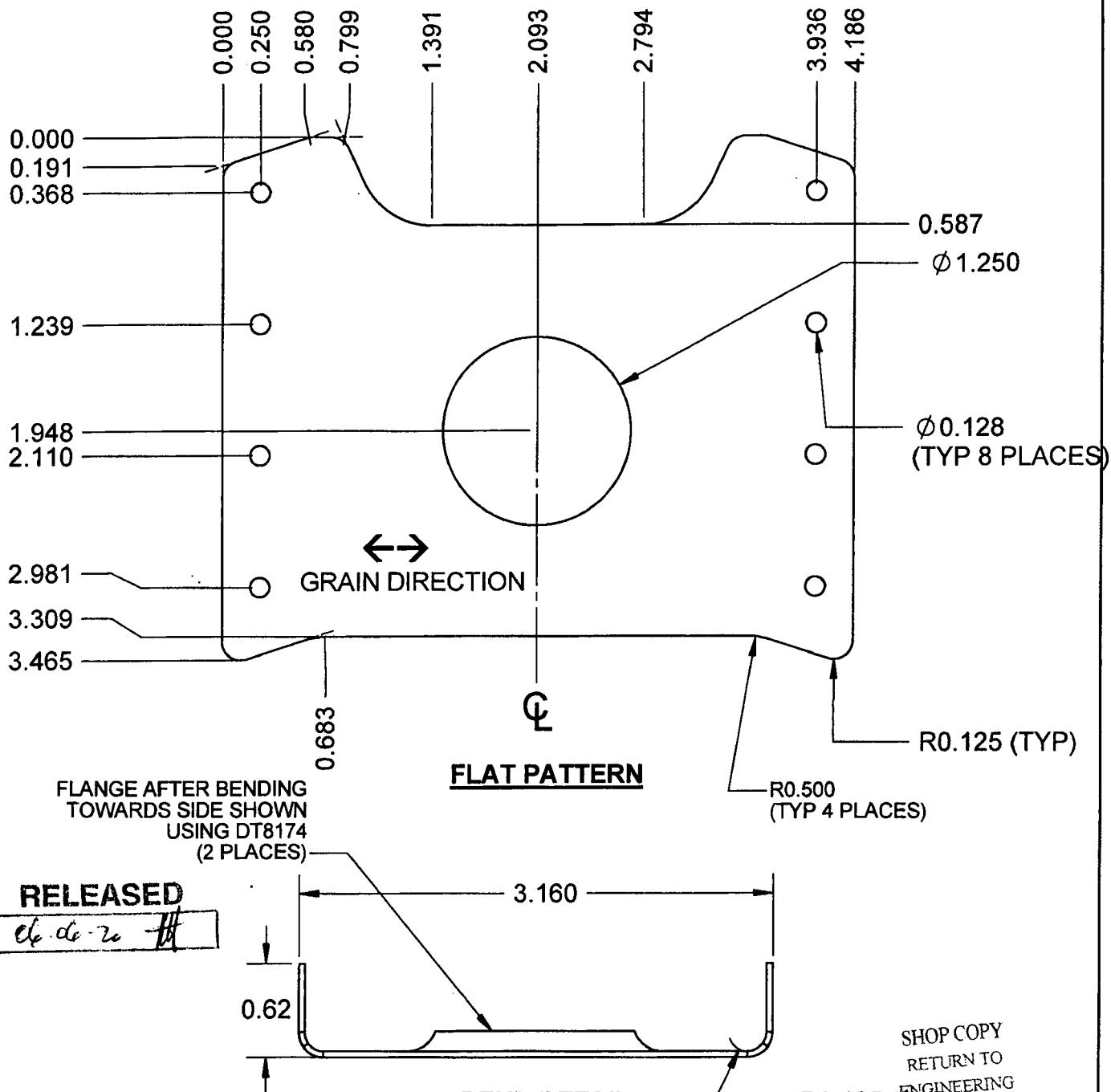
D3065-041 STEP LEG ASSEMBLY

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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S-040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

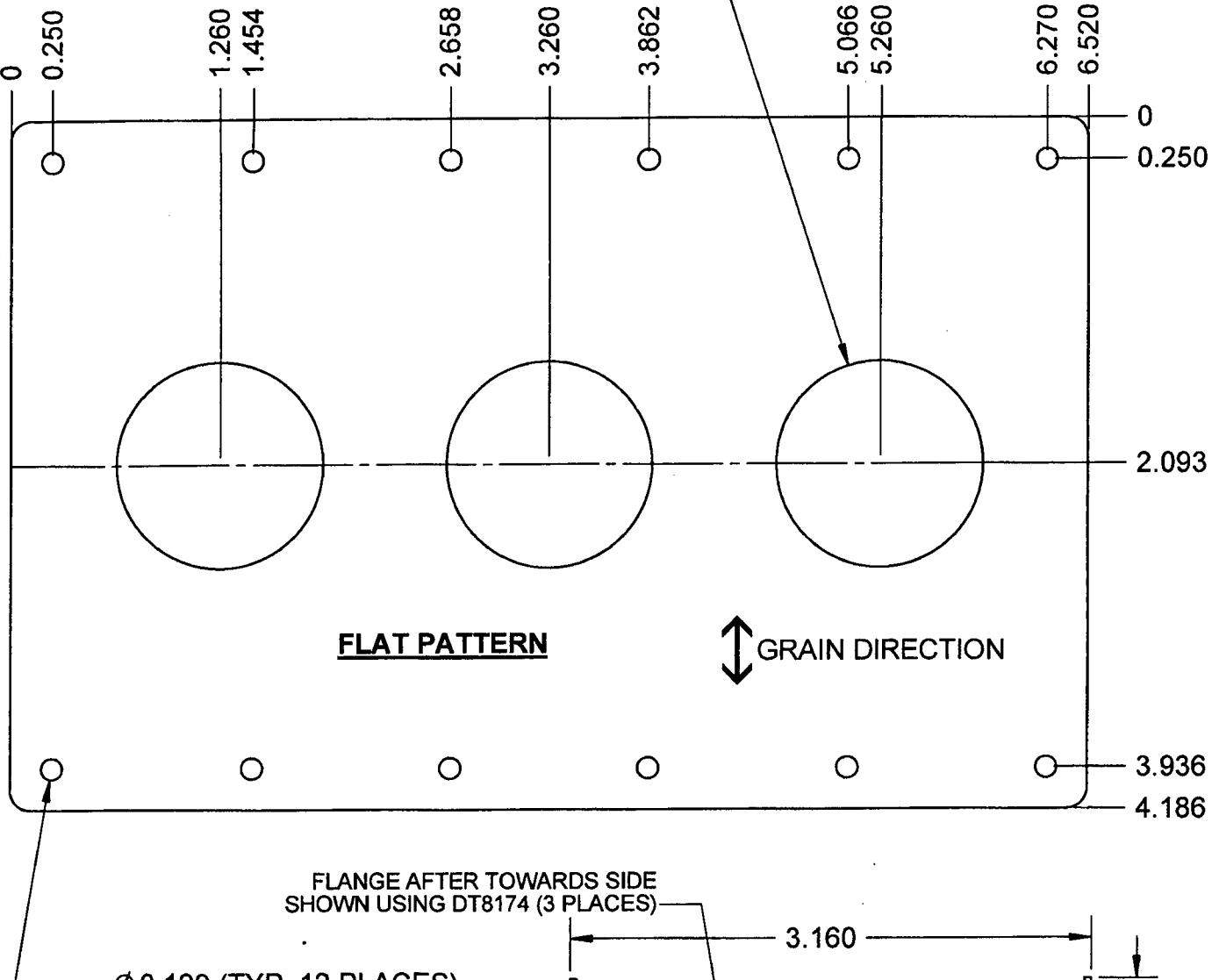
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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

 $\emptyset 1.250$ (TYP, 3 PLACES)**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

BEND DETAIL

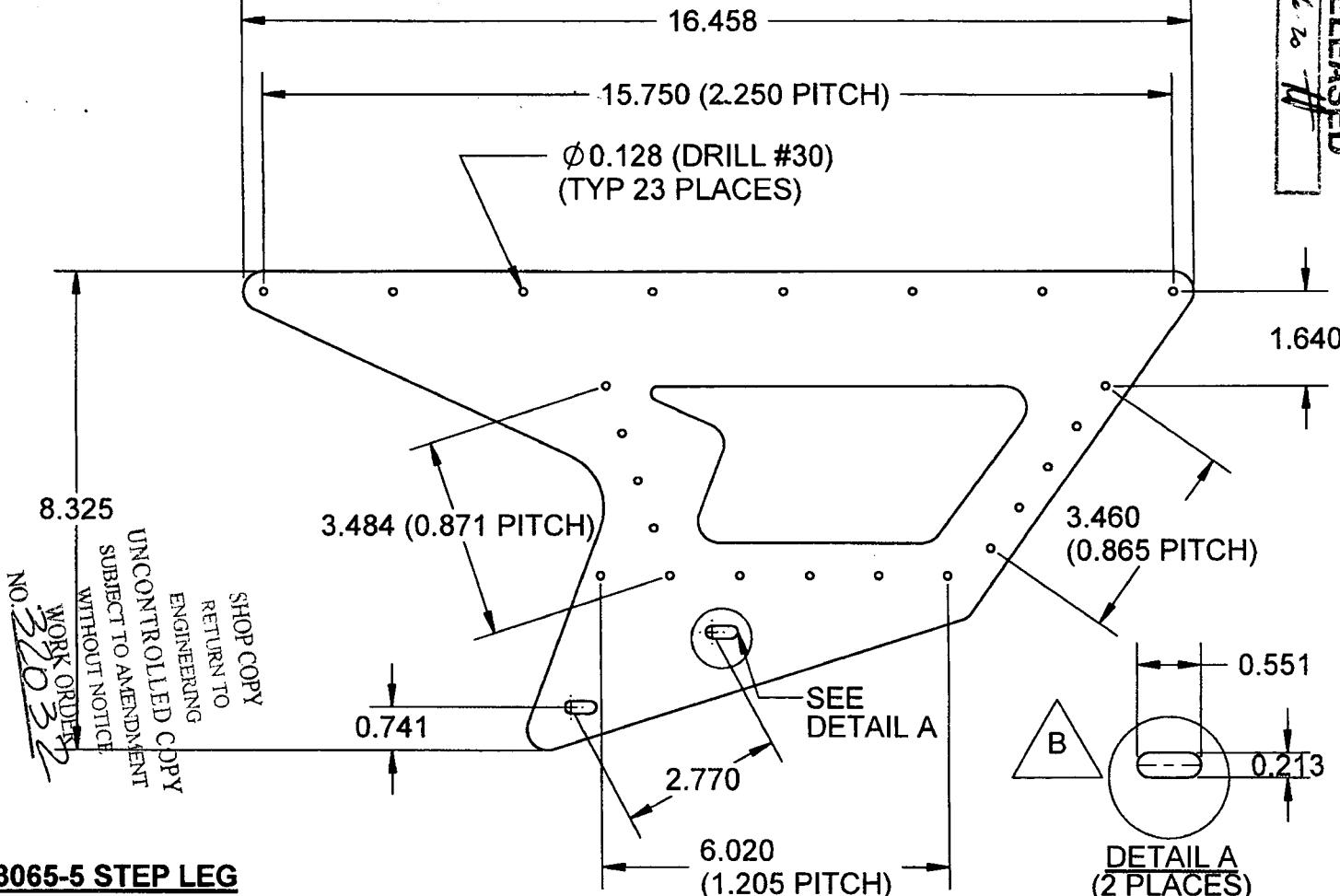
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DESIGN <i>CP</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>JL</i>	DRAWING NO. D3065
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	REV. B SHEET 4 OF 5 SCALE 1:3

RELEASED
06.06.20 - JL**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRPT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

